

Work Order ID 133344

Thursday, June 04, 2015 3:10:20 PM

V800 DM L/H

133344

Page 1

Item ID: D205-634-041 REPAIR

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube Fits LH or RH

Stop ***NS2***Start Date: 6/4/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00 ***1***

Customer: CROTO01

Reference: RMA RA112060-1

Approvals: Process Plan: ME Date: 15-6-4 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580-041	F								

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT RA112060
D205-634-041 X 1D205-634-041 BATCH NUMBER UNKNOWN WAS SENT FOR REPAIR
WITH BROKEN CROSSBOLTS

SKIDTUBES HAVE FLOWN

PERFORM REWORK AS PER REPAIR SCHEME RS1010

SCRAP PLUGS D2594-1 AND O-RING D2594-3 X 28 AND REPLACE WITH
NEW ONES

DP 15-6-7

110

0.00

110

Small Fab

Small Fab

Memo

0.00

REWORK PER RS1010

DP 15-6-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 133344

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Page 2

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Accept

N900040100

Setup Start

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Item Name: Replacement Skidtube Fits LH or RH

Stop

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1

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1

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 15-06-10 PD

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

DAS
02
9-00

JUN 10 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

① d DAS
29
9-00 15/06/11MFE
15-6-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Picklist Print

Thursday, June 04, 2015 3:10:13 PM

Page 1

Work Order ID: 133344

133344

Parent Item: D205-634-041 REPAIR

D205-634-041 REPAIR

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 6/4/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D205-634-041 REPAIR

Manufactured No

Each 2.0000

1

D205-634-041 REPAIR

Replacement Skidtube Fits LH or RH

**

xxx UMF 15-6-4

Location

Loc Qty

Loc Code

FG

-2

D4202-1

Manufactured No

Each 82.0000

20

D4202-1

Spacer

**

DP 15-6-8

Location

Loc Qty

Loc Code

LG002

82

129565

82

20

D2594-1 / B131092

x16

D2594-3 / M130546

x16

21 1310664

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD	Work Order:	1333404
Description: Repair Scheme for Canadian D205-634-041 Skidtube (Replacing crack crossbolt spacers)		
Drawing: D2580-041	Repair Scheme:	RS1010
Part No: D205-634-041	Page:	1 of 1
Batch No:	Qty:	

[illegible]

DQA: _____ Date: _____



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Description: Repair Scheme for Canadian D205-634-041 Skidtube (Replacing crack crossbolt spacers)		
Drawing: D2580-041	Repair Scheme:	RS1010
Part No: D205-634-041	Page:	2 of 1
Batch No:	Qty:	

Rev	Date	Change Description	Prepared	Checked	Approved
A	13.04.04	New Issue	DD		

U:\Admin\Forms\RepairschemblA.doc

Rev. A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

RA112060

Received @ May 21, 2015
Inspected @ June 2, 2015

CUSTOMER: ROTORCRAFT SUPPORT
CUSTOMER CONTACT: VERONICA LOZANO
SHIPPED FROM: CALIFORNIA USA

Instructions for RA112060 D205-364-041

- 2 D205-364-041 batch number unknown was sent for repair with broken cross bolt. Skidtubes has flown
- Perform rework as per **repair scheme RS1010**
- Scrap plugs D2594-1 and O-ring D2594-3 x28 and replace with new ones
- Customer is not concerned with paint
- Identify and sent back to customer under repair and new batch number

Time Estimate: 4 hours per tube

Departments Required: quality, skidtube, finishing

Pictures Attached: N/A

QTY INSPECTED: 2x D205-634-041

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause				FAULT CATEGORY																					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

REPAIRABLE OR REWORK

CUSTOMER San Diego Fire / RSI
JOB NO. 16231 DATE 4/7/15
PART NO. D205-634-041 PART NAME SKID TUBE ASSY
P.O. NO. _____ SER. NO. _____
NO. OF PIECES 1
DISPOSITION Multiple cracks in Saddle Holes
INSP. [Signature] STAMP 27457817
REASON FOR REWORK (Use reverse side)

LA 112060

DAS
9
9-89
15-06-02